



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200



D4712-3
Job Sheet 167166

Part No: D4712-3

Job Qty: 30 ea

Part Name: Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/25/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	30 Ea		11/9/17	0.00	0.00	Start Up Waterjet1	SC
100	Waterjet	30 pcs		11/9/17	0.00	3.34	Waterjet1	SC
110	QC	30 pcs		11/9/17	0.00	0.00	QC2	SC DAE
120	QC	30 pcs		11/9/17	0.00	0.00	QC8	38
130	Brake NC	30 pcs		11/9/17	0.00	4.04	Brake NC 2	38 3.89
140	QC	30 pcs		11/9/17	0.00	0.00	QC5	38
150	HandFinish	30 pcs		11/10/17	0.00	1.45	HandFinish1	2017-12-07 38
160	QC	30 pcs		11/10/17	0.00	0.00	QC7	38
170	Packaging	30 pcs		11/10/17	0.00	0.00	Packaging3	57716A AT
180	QC21-SA	30 Ea		11/10/17	0.00	0.00	QC21	

Part Op 100 - 1-Cut as per Dwg Dwg Rev: C Prog Rev: C 2-Deburr if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Bend as per dwg C'sink holes as per dwg

140 - QC5- Inspect part completeness to step on W/O

150 - Chemical Conversion Coat per QSI005 4.1

160 - QC7-Inspect Chemical Conversion Coat

170 - Identify as per dwg & Stock Location: _____

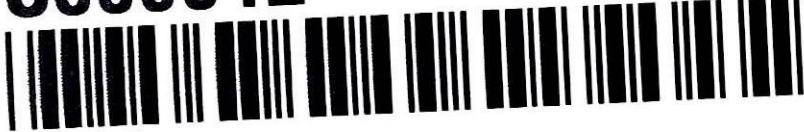
180 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6S.050	5	44	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	0.098Inches + 0.004 - 0.001	0.102 0.097	Diameter	
2	Bracket	0.250Inches + 0.005 - 0.001	0.255 0.249	Diameter	
3	Bracket	0.500Inches + 0.006 - 0.001	0.506 0.499	Diameter	
4	Bracket	0.380Inches + 0.006 - 0.001	0.386 0.379	Diameter	
5	Bracket	3.500Inches ± 0.030	3.530 3.470		

Work Order: _____ Part No.: _____ NCR No.: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS	
☐ Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved		☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab	☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite	☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier	☐ Engineering ☐ Quality ☐ Other
Date: _____		Step #: _____	QTY Effective: _____	MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			
Completed By _____		Lead hand / Supervisor Approval Verification _____			
QC / QA Coordinator Approval _____		Part No: D4712-3 Revision: _____ Operation: Start up Operation Change No: _____			
Bracket		S009012			
					
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com		☐ Instructions incomplete/Unclear ☐ Misaligned/off center ☐ Misread ☐ Finish ☐ Drawing ☐ Part Moved ☐ Part Lost/Missing ☐ Part Incorrect ☐ Over/Under tolerance ☐ Outside Dimensions ☐ Positioned Wrong			
☐ Pres ☐ Bent ☐ Cent ☐ Crack ☐ Crimp ☐ Cuffs ☐ Crush ☐ Heat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Drill Holes		☐ OTHER: _____			
Root Cause		No Re-verification Operator Offset/Setup Supplier Training Use for Testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due			
Environment Design Doc/Data Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified					

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>167/66</u> Part No. <u>D47/2-3</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☒</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Quality ☐																						
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Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification <u>SB 17/12/07</u>																	
1 part was scrap at the net up out of tolerance				Scrap - destroyed No replace				QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ ☒ Offset/Setup Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ ☒ Out of Sequence Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																	
		OTHER : _____																							



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Inventory

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: M6061T6S.050 Revision: 6061-T6 .050 Sheet														
100	Receive sf	S009011	167166	0 sf	0	M131352	Start Up Waterjet1		Stock	11/11/2017	Issue Container			
Operation Totals:		1		0	0									
Part Totals:		1		0	0									
Totals:		1		0	0									

Plex 1/9/2018 8:31 AM Dart.Boucher.Sylvie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								